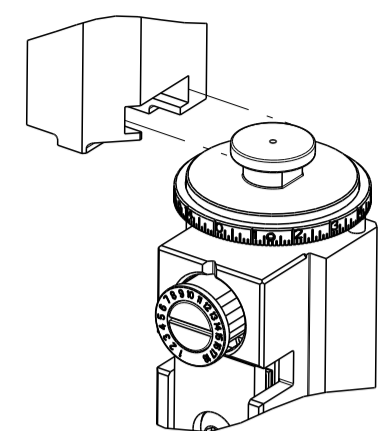


| PART NUMBER | REVISION | DESCRIPTION                     | FEED TYPE |
|-------------|----------|---------------------------------|-----------|
| 2151486-2   | C        | FINE CRIMP HEIGHT ADJUST        | PNEUMATIC |
| 7-2151486-2 | C        | PNEUMATIC AND CRIMP TOOLING KIT | PNEUMATIC |
| 7-2151486-7 | A        | CRIMP TOOLING KIT               | -         |

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.78 mm [.070] | F    |
| INSUL           | 2.29 mm [.090] | O    |

APPLICATOR INSTRUCTIONS 408-35042

| TERMINAL DATA: TE TERMINAL         |             | TE CRIMP SPECIFICATION       |             |
|------------------------------------|-------------|------------------------------|-------------|
| TERMINAL NAME: TAB 5.8 X 0.8       |             |                              |             |
| WIRE STRIP LENGTH                  |             | INSULATION DIAMETER RANGE    |             |
| 3.00-3.60 mm [.118-.142 IN]        |             | Ø1.15-1.60 mm [.045-.063 IN] |             |
| TERMINAL APPLICATION SPECIFICATION | 114-18052   |                              |             |
| TERMINALS APPLIED                  |             |                              |             |
| TE TERMINAL                        | TE TERMINAL | TE TERMINAL                  | TE TERMINAL |
| 969007-1                           |             |                              |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]        | CRIMP HEIGHT REFERENCE SETTING |
|-----------|-------------------------------|--------------------------------|
| 0.50mm2   | 1.21 +/- 0.03 [.048 +/- .001] | 4.3                            |
| 0.35mm2   | 1.14 +/- 0.03 [.045 +/- .001] | 5.1                            |
| 0.25mm2   | 1.10 +/- 0.03 [.043 +/- .001] | 5.4                            |
| 0.20mm2   | 1.08 +/- 0.03 [.043 +/- .001] | 5.5                            |

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
- 6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

| LOC | DIST | REVISIONS |     |               |           |     |      |
|-----|------|-----------|-----|---------------|-----------|-----|------|
| A   | 66   | P         | LTN | DESCRIPTION   | DATE      | OWN | APVD |
|     |      | A         |     | RELEASED      | 02NOV2012 | KH  | SX   |
|     |      | B         |     | ECR-18-007035 | 09MAY2018 | KH  | JDG  |
|     |      | C         |     | ECR-19-009765 | 22JUN2019 | TB  | TE   |

|   |     |     |             |                                     |         |
|---|-----|-----|-------------|-------------------------------------|---------|
| - | 1   | 1   | 2119641-1   | FEED CAM, AIR FEED                  | 248     |
| - | 1   | 1   | 2119082-8   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244     |
| - | 1   | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243     |
| - | 1   | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242     |
| - | 1   | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241     |
| - | 1   | 1   | 2844940-1   | AIR FEED MODULE                     | 238     |
| - | REF | REF | 994970-2    | COUNTER, MAGNETIC                   | 164     |
| - | 1   | 1   | 2844908-1   | SCREW, LOCKING                      | 99      |
| - | 1   | 1   | 2844907-1   | POST, LOCKING                       | 98      |
| - | 1   | 1   | 455888-4    | SPACER, CRIMPER                     | 82      |
| - | 1   | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71      |
| - | 1   | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67      |
| - | 2   | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66      |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 60      |
| - | 1   | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59      |
| - | 1   | 1   | 1338685-1   | PAWL, FEED                          | 56      |
| - | 4   | 4   | 2168083-3   | SCR, SKT HD CAP, RoHS, M4 X 12.0    | 54      |
| - | 2   | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53      |
| - | 1   | 1   | 1803382-2   | HOLD DOWN, SPRING LOADED            | 50      |
| - | 1   | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49      |
| - | 1   | 1   | 1803583-9   | APPLICATOR BASIC ASSEMBLY, SF       | 46      |
| - | 1   | 1   | 1803515-1   | RAM ASSEMBLY, SF ATLANTIC           | 44      |
| - | 1   | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41      |
| - | 1   | 1   | 1-1752356-1 | SUPPORT, TERMINAL                   | 34      |
| - | 2   | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33      |
| - | 2   | 2   | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30      |
| - | 1   | 1   | 2844992-2   | ASSEMBLY, STRIP GUIDE               | 29      |
| - | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28      |
| - | 1   | 1   | 1320928-6   | STRIP GUIDE                         | 24      |
| - | 1   | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21      |
| - | 2   | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20      |
| - | 1   | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19      |
| - | 1   | 1   | 2119806-1   | INSERT, SHEAR                       | 13      |
| - | 1   | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12      |
| - | 1   | 1   | 1-356885-4  | STOP, SHEAR                         | 11      |
| - | 1   | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10      |
| - | 1   | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9       |
| - | 1   | 2   | 1333203-3   | ANVIL, COMBINATION                  | 8       |
| - | -   | -   | -           | -                                   | 7       |
| - | -   | -   | -           | -                                   | 6       |
| - | 1   | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5       |
| - | 1   | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4       |
| - | 1   | 2   | 1-2119784-8 | CRIMPER, INSULATION O PREMIUM       | 3       |
| - | 1   | 1   | 1-455888-0  | SPACER, CRIMPER                     | 2       |
| - | 1   | 2   | 3-456404-2  | CRIMPER, WIRE PREMIUM               | 1       |
| - | 77  | -72 | -2          | PART NO                             | ITEM NO |

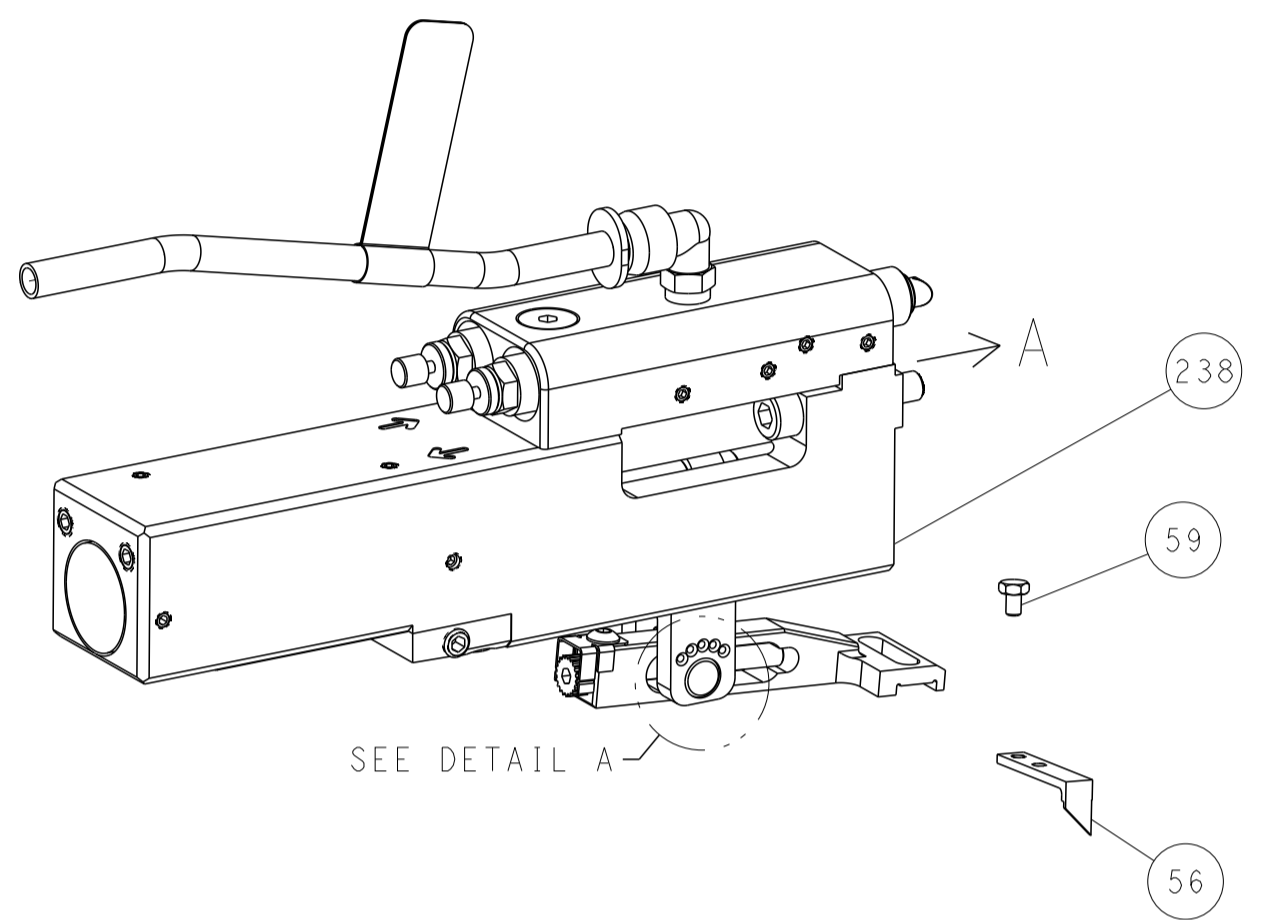
ATLANTIC VERSION  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|             |         |                                        |         |                         |         |                      |        |                       |            |                                        |       |
|-------------|---------|----------------------------------------|---------|-------------------------|---------|----------------------|--------|-----------------------|------------|----------------------------------------|-------|
| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWG: H. HUANG 06SEP2012 |         | CHK: S. XI 06SEP2012 |        | APVD: S. XI 06SEP2012 |            | NAME: Ocean Side Feed Applicator       |       |
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                 | 4 PLC ± | ANGLES               | FINISH | WEIGHT                | SCALE: 1:2 | SHEET 1 OF 4                           | REV C |
| MATERIAL:   |         | FINISH:                                |         | CAGE CODE: 00779        |         | DRAWING NO: 2151486  |        | RESTRICTED TO:        |            | Customer Accessible Production Drawing |       |

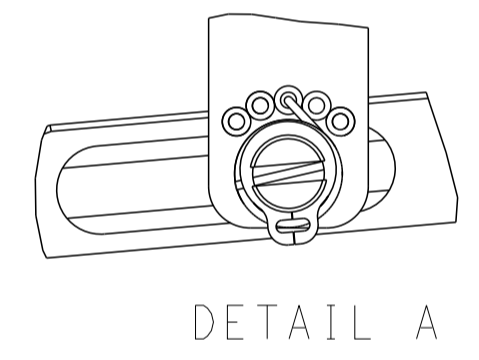
| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTN | DESCRIPTION | DATE | DWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |
|     |      |           |     |             |      |     |      |
|     |      |           |     |             |      |     |      |

# FEED TYPE

## PNEUMATIC

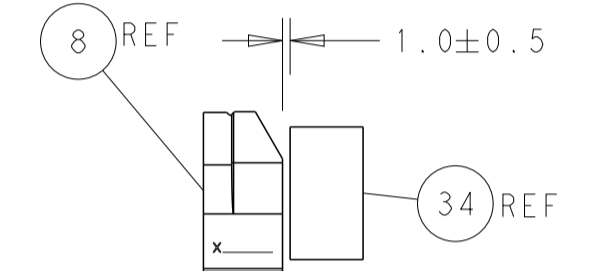
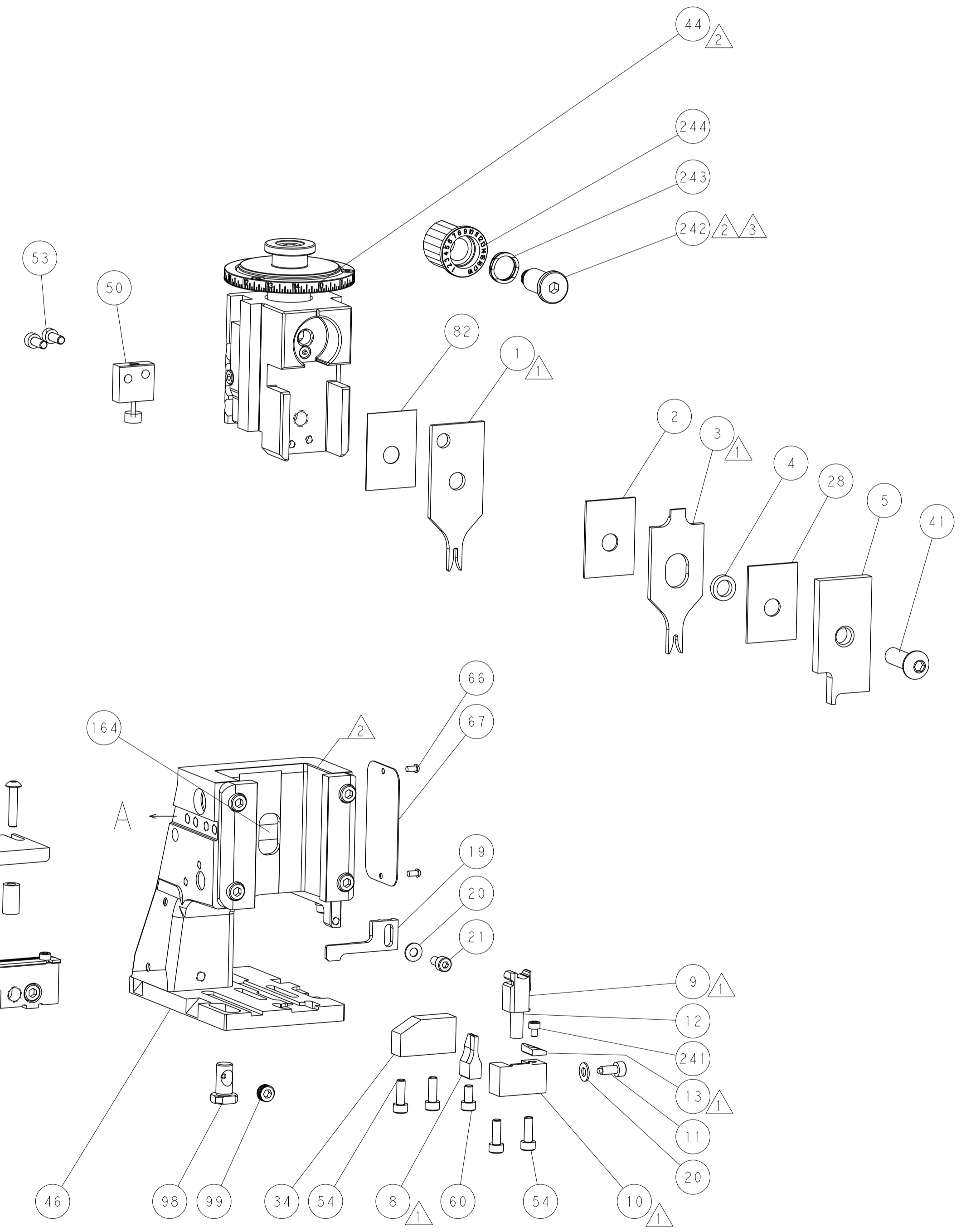
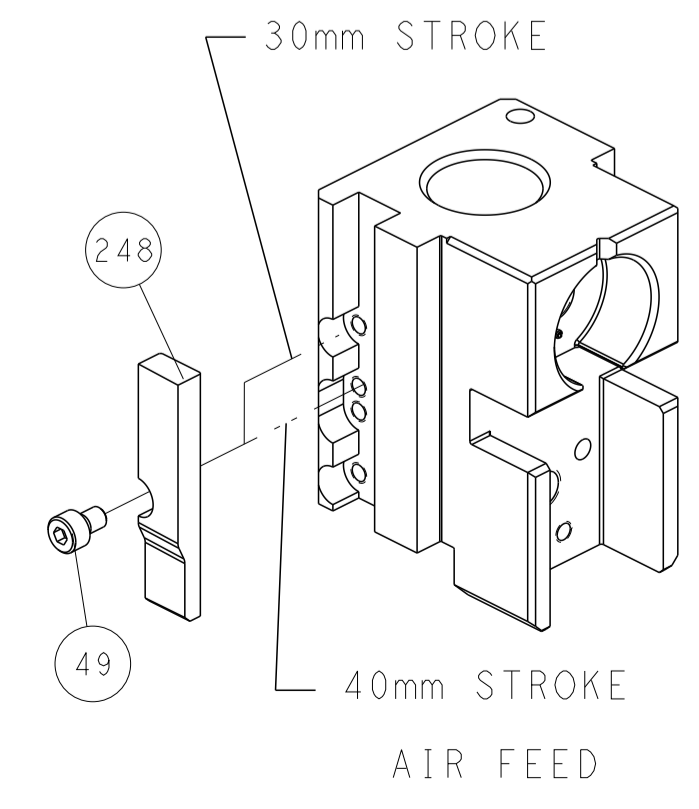


## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

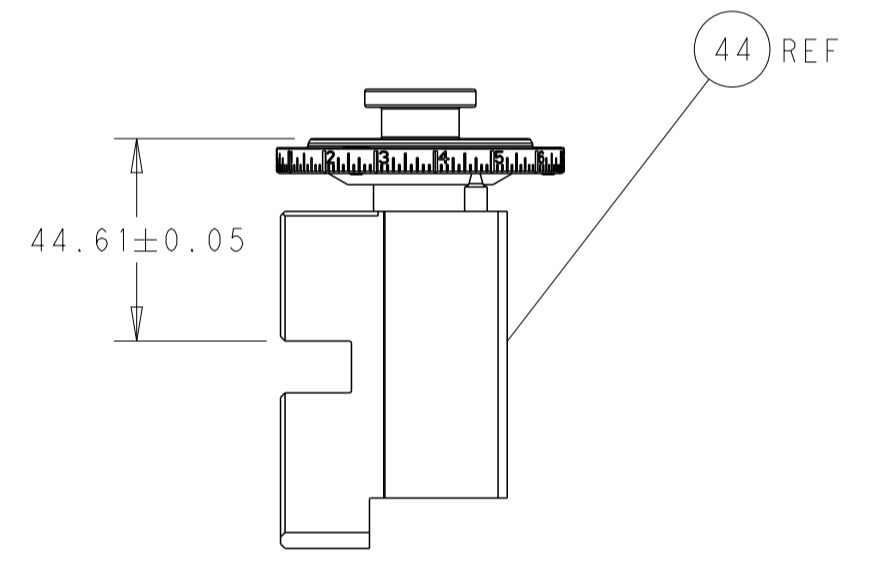


DETAIL A

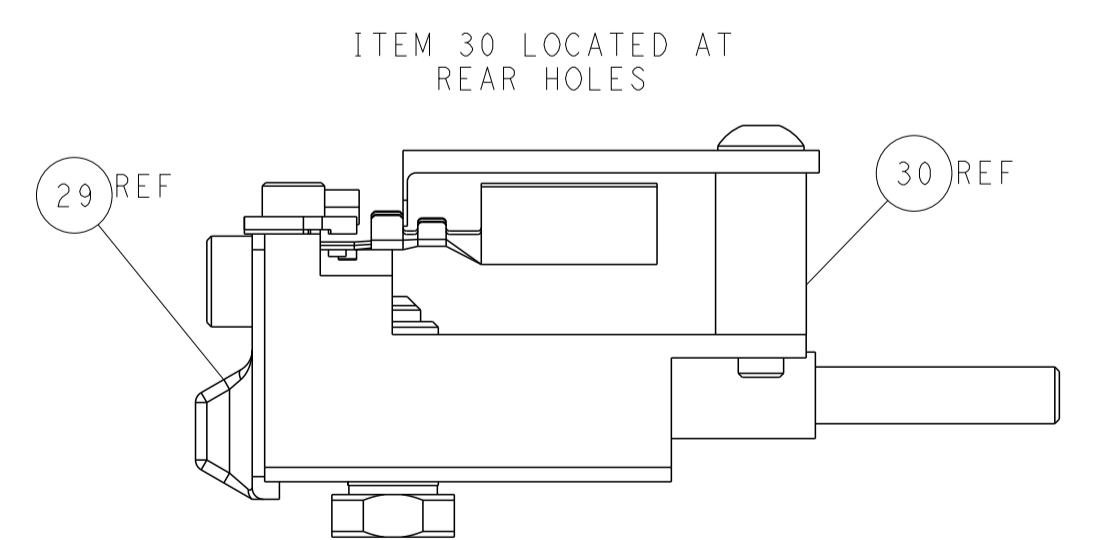
## CAM POSITION



TERMINAL SUPPORT LOCATION



RAM SET-UP



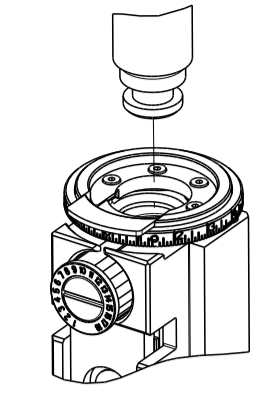
FEED TRACK POSITION GUIDE BY INSULATION BARREL

**ATLANTIC VERSION**  
 Shown on sheets 1 of 4 & 2 of 4  
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

|                                                                                                                                             |  |                                                                                                                                          |                                              |
|---------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|
| <small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION 20. COPYRIGHT 20 BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small> |  | DWN: H. HUANG 06SEP2012<br>CHK: S. XI 06SEP2012<br>APVD: S. XI 06SEP2012                                                                 | TE Connectivity<br>Harrisburg, PA 17105-3608 |
| DIMENSIONS: mm<br>TOLERANCES UNLESS OTHERWISE SPECIFIED:<br>0 PLC ±<br>1 PLC ±<br>2 PLC ±<br>3 PLC ±<br>4 PLC ±<br>ANGLES ±<br>FINISH       |  | NAME: Ocean Side Feed Applicator<br>PRODUCT SPEC:<br>APPLICATION SPEC:<br>SIZE: A1<br>CAGE CODE: 00779<br>DRAWING NO: 2151486<br>WEIGHT: | RESTRICTED TO:                               |
| MATERIAL:                                                                                                                                   |  | SCALE: 1:2<br>SHEET: 2 of 4<br>REV: C                                                                                                    | Customer Accessible Production Drawing       |

| PART NUMBER | REVISION | DESCRIPTION              | FEED TYPE |
|-------------|----------|--------------------------|-----------|
| 2-2151486-2 | C        | FINE CRIMP HEIGHT ADJUST | PNEUMATIC |
| 7-2151486-7 | A        | CRIMP TOOLING KIT        | -         |

PACIFIC VERSION TERMINATOR  
 INTERFACE ADAPTER



| APPLICATOR DATA |                |      |
|-----------------|----------------|------|
| CRIMP           | SIZE           | TYPE |
| WIRE            | 1.78 mm [.070] | F    |
| INSUL           | 2.29 mm [.090] | O    |

APPLICATOR INSTRUCTIONS  
 408-35042

| TERMINAL DATA: TE TERMINAL                       |             | TE CRIMP SPECIFICATION                                    |             |
|--------------------------------------------------|-------------|-----------------------------------------------------------|-------------|
| TERMINAL NAME: TAB 5.8 X 0.8                     |             |                                                           |             |
| WIRE STRIP LENGTH<br>3.00-3.60 mm [.118-.142 IN] |             | INSULATION DIAMETER RANGE<br>Ø1.15-1.60 mm [.045-.063 IN] |             |
| TERMINAL APPLICATION SPECIFICATION               | 114-18052   | -                                                         | -           |
| TERMINALS APPLIED                                |             |                                                           |             |
| TE TERMINAL                                      | TE TERMINAL | TE TERMINAL                                               | TE TERMINAL |
| 969007-1                                         |             |                                                           |             |

| WIRE SIZE | CRIMP HEIGHT mm [INCH]     | CRIMP HEIGHT REFERENCE SETTING |
|-----------|----------------------------|--------------------------------|
| 0.50mm2   | 1.21+/-0.03 [.048+/-0.001] | 4.3                            |
| 0.35mm2   | 1.14+/-0.03 [.045+/-0.001] | 5.1                            |
| 0.25mm2   | 1.10+/-0.03 [.043+/-0.001] | 5.4                            |
| 0.20mm2   | 1.08+/-0.03 [.043+/-0.001] | 5.5                            |

- RECOMMENDED SPARE PARTS
  - REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
  - APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
  - CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
  - TERMINAL PITCH NOT COMPATIBLE WITH MECHANICAL FEED.
6. UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.

**\*WARNING**  
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING, REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

| LOC | DIST | REVISIONS |     |             |      |     |      |
|-----|------|-----------|-----|-------------|------|-----|------|
|     |      | P         | LTN | DESCRIPTION | DATE | OWN | APVD |
| A   | 66   | -         | -   | SEE SHEET 1 | -    | -   | -    |

|   |     |             |                                     |     |
|---|-----|-------------|-------------------------------------|-----|
| - | 1   | 2119082-8   | CAM, SNAIL, INSULATION ADJUSTMENT   | 244 |
| - | 1   | 2079764-1   | WASHER, WAVE SPRING, CREST-TO-CREST | 243 |
| - | 1   | 2119083-1   | RETAINER, INSULATION DIAL           | 242 |
| - | 1   | 7-18023-7   | SCR, SKT HD CAP M3 X 4.0            | 241 |
| - | 1   | 2844940-1   | AIR FEED MODULE                     | 238 |
| - | REF | 994970-2    | COUNTER, MAGNETIC                   | 164 |
| - | 1   | 2119641-2   | FEED CAM, AIR FEED                  | 151 |
| - | 1   | 2168083-8   | SCR, SKT HD CAP, RoHS, M4 X 16      | 144 |
| - | 4   | 2168083-9   | SCR, SKT HD CAP, RoHS, M4 X 20      | 143 |
| - | 1   | 1-1803583-0 | APPLICATOR BASIC ASSEMBLY, SF       | 141 |
| - | 1   | 1803516-1   | RAM ASSEMBLY, SF PACIFIC            | 140 |
| - | 1   | 2844908-1   | SCREW, LOCKING                      | 99  |
| - | 1   | 2844907-1   | POST, LOCKING                       | 98  |
| - | 1   | 455888-4    | SPACER, CRIMPER                     | 82  |
| - | 1   | 1803607-3   | DOCUMENTATION PACKAGE               | 71  |
| - | 1   | 2119740-1   | TAG, IDENTIFICATION                 | 67  |
| - | 2   | 2168078-1   | SCREW, DRIVE, RH, RoHS, 2 x .188    | 66  |
| - | 1   | 5-18022-5   | SCR, HEX HD CAP, M4 X 6.0           | 59  |
| - | 1   | 1338685-1   | PAWL, FEED                          | 56  |
| - | 2   | 1-2168083-0 | SCR, SKT HD CAP, RoHS, M4 X 10      | 53  |
| - | 1   | 1803382-2   | HOLD DOWN, SPRING LOADED            | 50  |
| - | 1   | 18023-9     | SCR, SKT HD CAP M4 X 6.0            | 49  |
| - | 1   | 1803602-1   | SCR, BHSC, RoHS (M8 X 25)           | 41  |
| - | 1   | 1-1752356-1 | SUPPORT, TERMINAL                   | 34  |
| - | 2   | 2079383-5   | SCR, BHSC, RoHS (M4 X 20)           | 33  |
| - | 2   | 2-2844962-6 | SPACER, CYLINDRICAL, STRIP GUIDE    | 30  |
| - | 1   | 2844992-2   | ASSEMBLY, STRIP GUIDE               | 29  |
| - | 1   | 1-455888-0  | SPACER, CRIMPER                     | 28  |
| - | 1   | 1320928-6   | STRIP GUIDE                         | 24  |
| - | 1   | 2168083-2   | SCR, SKT HD CAP, RoHS, M4 X 8.0     | 21  |
| - | 2   | 1-18028-2   | WASHER, FLAT, REG M4                | 20  |
| - | 1   | 2119533-1   | STRIPPER, SIDE FEED                 | 19  |
| - | 1   | 2119806-1   | INSERT, SHEAR                       | 13  |
| - | 1   | 3-22280-3   | SPRING, COMPRESSION                 | 12  |
| - | 1   | 1-356885-4  | STOP, SHEAR                         | 11  |
| - | 1   | 2119805-1   | SHEAR HOLDER, FRONT                 | 10  |
| - | 1   | 318707-1    | FLOATING SHEAR, FRONT               | 9   |
| - | 1   | 1333203-3   | ANVIL, COMBINATION                  | 8   |
| - | -   | -           | -                                   | 7   |
| - | -   | -           | -                                   | 6   |
| - | 1   | 2119757-4   | DEPRESSOR, SHEAR                    | 5   |
| - | 1   | 238011-9    | BLOCK, CRIMPER SPACER               | 4   |
| - | 1   | 1-2119784-8 | CRIMPER, INSULATION O PREMIUM       | 3   |
| - | 1   | 1-455888-0  | SPACER, CRIMPER                     | 2   |
| - | 1   | 3-456404-2  | CRIMPER, WIRE PREMIUM               | 1   |

| DIMENSIONS: |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | MATERIAL: |         | FINISH: |        | WEIGHT: |  | SCALE: |  |
|-------------|---------|----------------------------------------|---------|-----------|---------|---------|--------|---------|--|--------|--|
| mm          | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±   | 4 PLC ± | ANGLES  | FINISH |         |  | SCALE  |  |
|             |         |                                        |         |           |         |         |        |         |  | 1:2    |  |

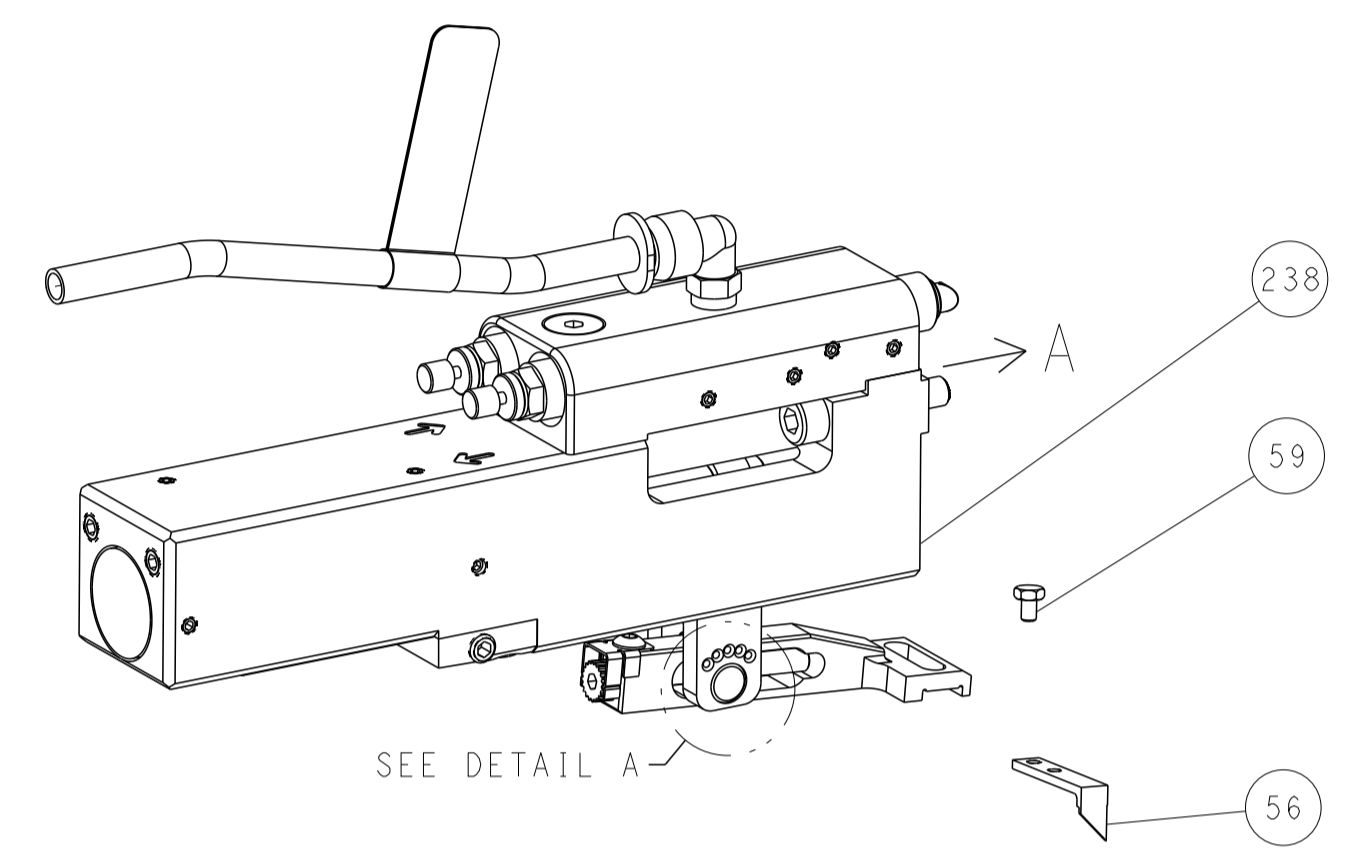
| ITEM NO | PART NO | DESCRIPTION | ITEM NO     |
|---------|---------|-------------|-------------|
| -77     | -22     | PART NO     | DESCRIPTION |

|                                        |           |            |                              |
|----------------------------------------|-----------|------------|------------------------------|
| OWN                                    | H. HUANG  | 06SEP2012  | TE Connectivity              |
| CHK                                    | S. XI     | 06SEP2012  | Harrisburg, PA 17105-3608    |
| APVD                                   | S. XI     | 06SEP2012  | NAME                         |
| PRODUCT SPEC                           |           |            | Ocean Side Feed              |
| APPLICATION SPEC                       |           |            | Applicator                   |
| SIZE                                   | CAGE CODE | DRAWING NO | RESTRICTED TO                |
| A1                                     | 00779     | 2151486    |                              |
| Customer Accessible Production Drawing |           |            | SCALE 1:2 SHEET 3 OF 4 REV C |

| LOC |    | DIST |     | REVISIONS   |      |     |      |
|-----|----|------|-----|-------------|------|-----|------|
| A   | 66 | P    | LTM | DESCRIPTION | DATE | OWN | APVD |
|     |    | -    |     | SEE SHEET 1 |      |     |      |
|     |    |      |     |             |      |     |      |
|     |    |      |     |             |      |     |      |

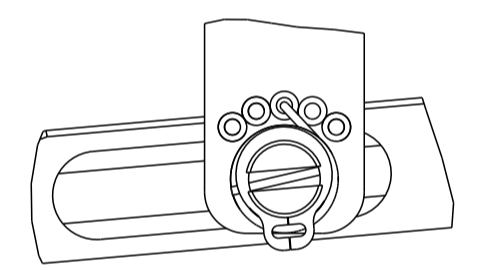
# FEED TYPE

## PNEUMATIC



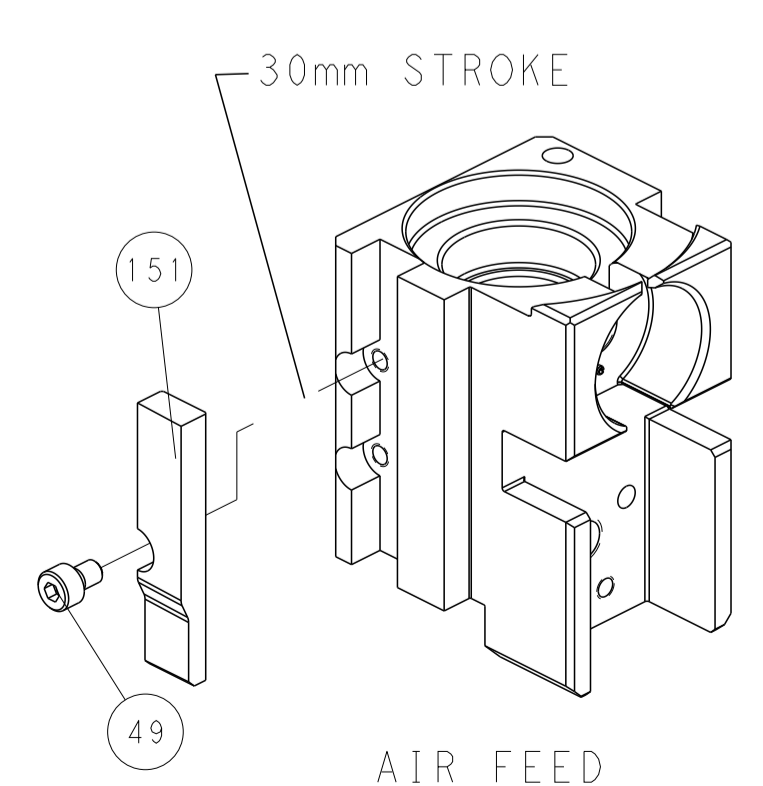
SEE DETAIL A

## FEED SPRING SETTING POSITION (SHOWN FROM REAR SIDE)

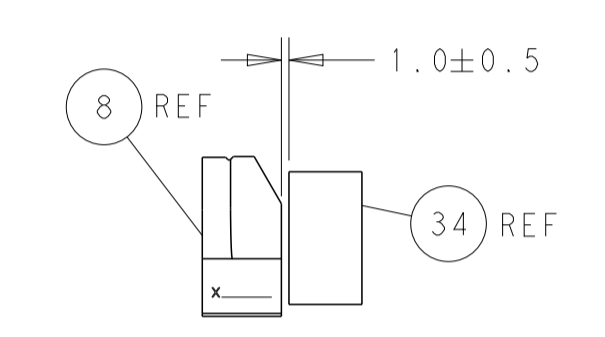
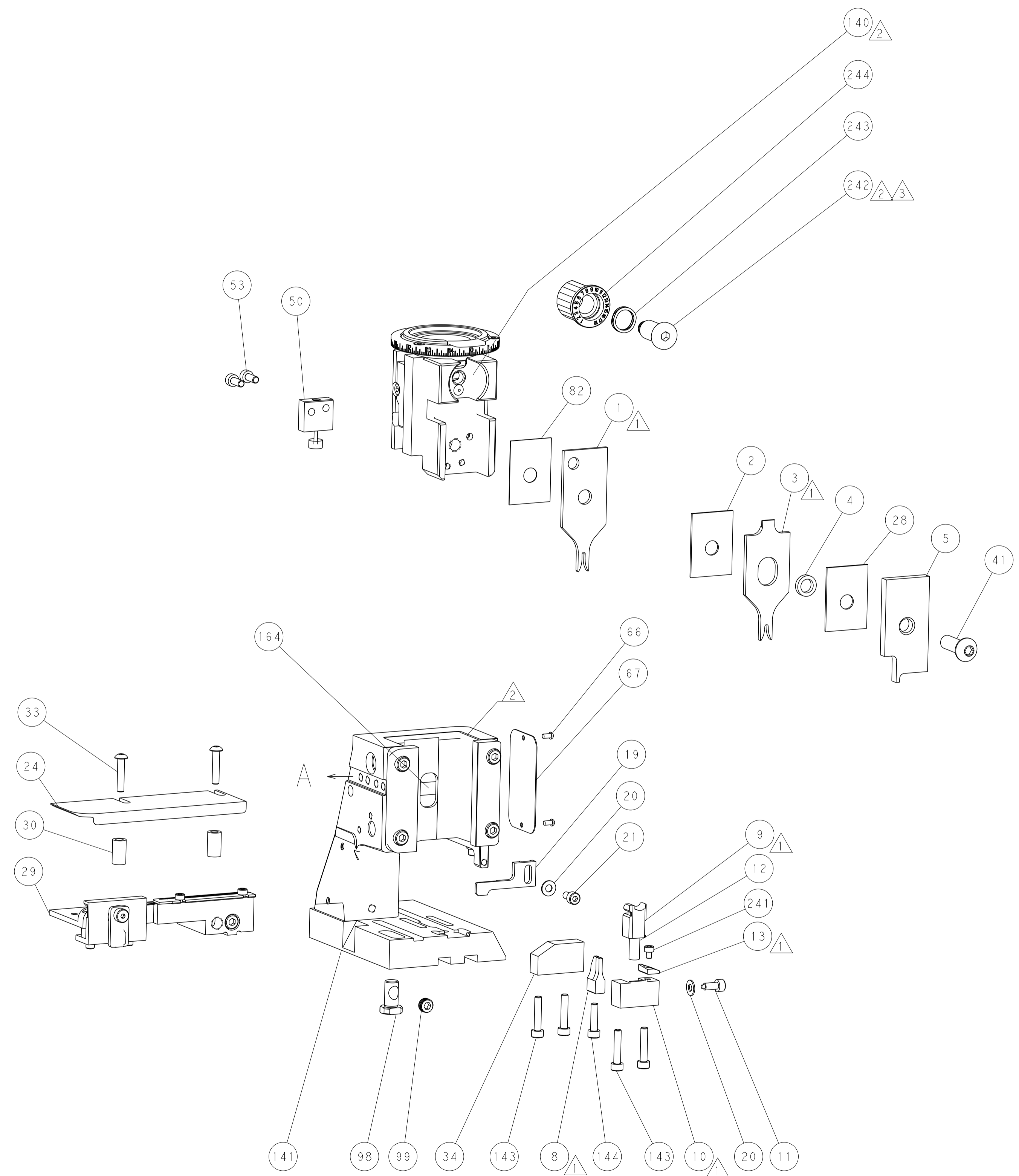


DETAIL A

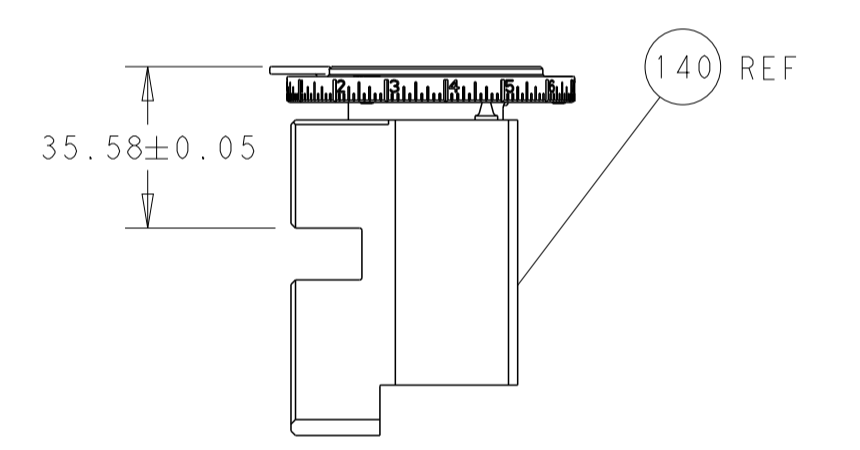
## CAM POSITION



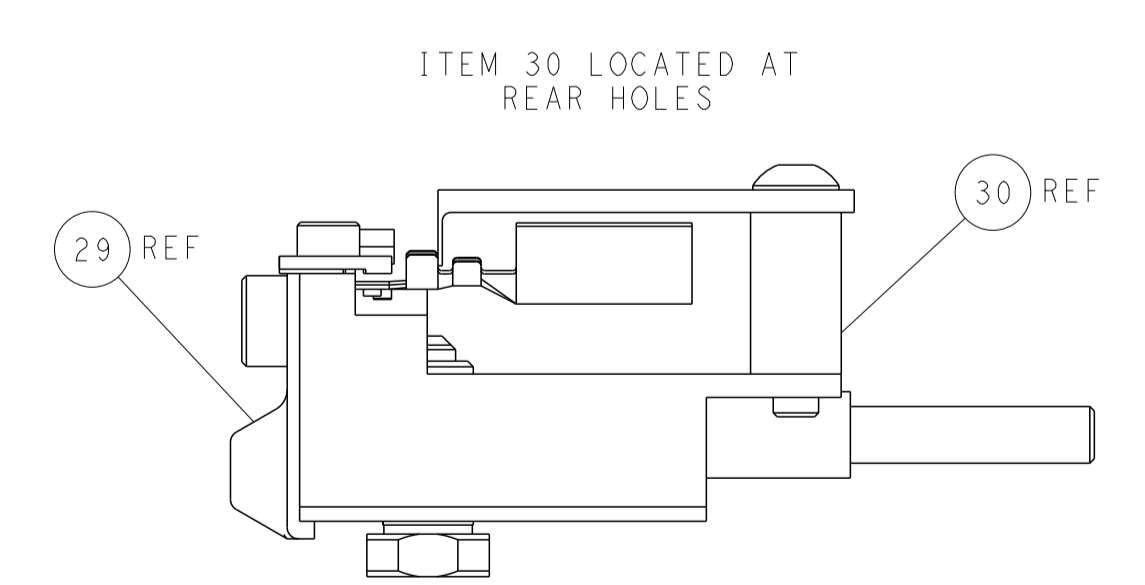
AIR FEED



TERMINAL SUPPORT LOCATION



RAM SET-UP



FEED TRACK POSITION GUIDE BY INSULATION BARREL

**PACIFIC VERSION**  
 Shown on sheets 3 of 4 & 4 of 4  
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

|                                        |         |                                        |         |                        |            |                      |                           |
|----------------------------------------|---------|----------------------------------------|---------|------------------------|------------|----------------------|---------------------------|
| DIMENSIONS:                            |         | TOLERANCES UNLESS OTHERWISE SPECIFIED: |         | DWN H. HUANG 06SEP2012 |            | TE Connectivity      |                           |
| mm                                     | 0 PLC ± | 1 PLC ±                                | 2 PLC ± | 3 PLC ±                | 4 PLC ±    | APVD S. XI 06SEP2012 | Harrisburg, PA 17105-3608 |
| MATERIAL:                              | FINISH: | WEIGHT:                                | SCALE:  | SIZE:                  | CAGE CODE: | DRAWING NO:          | RESTRICTED TO:            |
|                                        |         |                                        | 1:2     | A1                     | 00779      | ©=2151486            |                           |
| Customer Accessible Production Drawing |         |                                        |         | SHEET 4 OF 4 REV C     |            |                      |                           |